

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
 Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General		<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio					
						<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 98951

March-28-13 10:47:21 AM

98951

Page 2

Item ID: D3255-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Access Panel Assembly

Stop

NS2

Start Date: 4/01/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/01/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

3x / m / 13/08/28

130

Powdercoat

Powder Coating

Memo

START TIME:

8-40

0.00

OVEN TEMPERATURE:

320° F

9-10

140

QC3- Inspect Part Finish

0.00

3 ✓ 13-8-28 10:00

140

QC

Quality Control

Memo

0.00

150

Small Fab

0.00

-3

8/13/08/29

150

Small Fab

Small Fab

Memo

0.00

I-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg
D3255A/R 736 DOW CORNING ADHESIVE
Batch: M122346

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS									
			Rework Scrap Use-as-is Work Order Update	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	Skid-tube Machining Thermoforming Large Fab	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	Crosstube Small Fab Finishing Composite	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	Engineering Quality Other			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved														
FAULT CATEGORY														
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

Work Order ID 98951***98951***

Page 3

March-28-13 10:47:21 AM

Item ID: D3255-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Access Panel Assembly

Stop

NS2

Start Date: 4/01/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/01/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SwB DAS

27
9-89

0.00 13.8.29

3

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: ST/76 0.00

0.00

3x

80
13.8.29

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

13/9/30

EB-JR29

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Picklist Print

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Page 1

Work Order ID: 98951

Parent Item: D3255-042

Parent Item Name: Access Panel Assembly

Start Date: 4/01/13

Required Date: 4/01/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

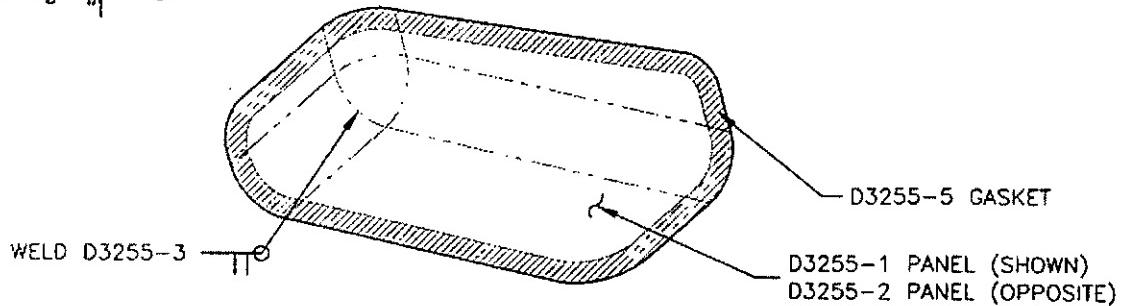
QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>						
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>						
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	<input type="checkbox"/>		Bend	<input type="checkbox"/>		Grain	<input type="checkbox"/>		Ovalized	<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/>		BOM/Route	<input type="checkbox"/>		Hardware	<input type="checkbox"/>		Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure
Cracks	<input type="checkbox"/>		Broken/Damaged	<input type="checkbox"/>		Inspection Incomplete	<input type="checkbox"/>		Part Incorrect	<input type="checkbox"/>	Weld
Crushed/Crimped	<input type="checkbox"/>		Burrs	<input type="checkbox"/>		Instructions Incomplete/Unclear	<input type="checkbox"/>		Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled
Cuffs	<input type="checkbox"/>		Contamination	<input type="checkbox"/>		Maintenance	<input type="checkbox"/>		Part Moved	<input type="checkbox"/>	
Heat Treat	<input type="checkbox"/>		Countersink	<input type="checkbox"/>		Mislabeled	<input type="checkbox"/>		Positioned Wrong	<input type="checkbox"/>	
Inspection Strip in Tube	<input type="checkbox"/>		Cut Too Short	<input type="checkbox"/>		Misread	<input type="checkbox"/>		Power Loss/Surge	<input type="checkbox"/>	
Ripples in Bend	<input type="checkbox"/>		Drill Holes	<input type="checkbox"/>		Offset	<input type="checkbox"/>		Other	<input type="checkbox"/>	
Torque Waves in Extrusion	<input type="checkbox"/>		Drawing	<input type="checkbox"/>		Out of Calibration	<input type="checkbox"/>			<input type="checkbox"/>	
Turning Sequence	<input type="checkbox"/>		Finish	<input type="checkbox"/>		Out of Sequence	<input type="checkbox"/>			<input type="checkbox"/>	
Wave/Twist in Tube	<input type="checkbox"/>		Folio	<input type="checkbox"/>		Outside Dimensions	<input type="checkbox"/>			<input type="checkbox"/>	

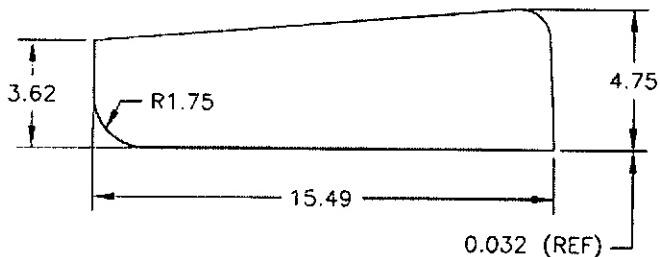
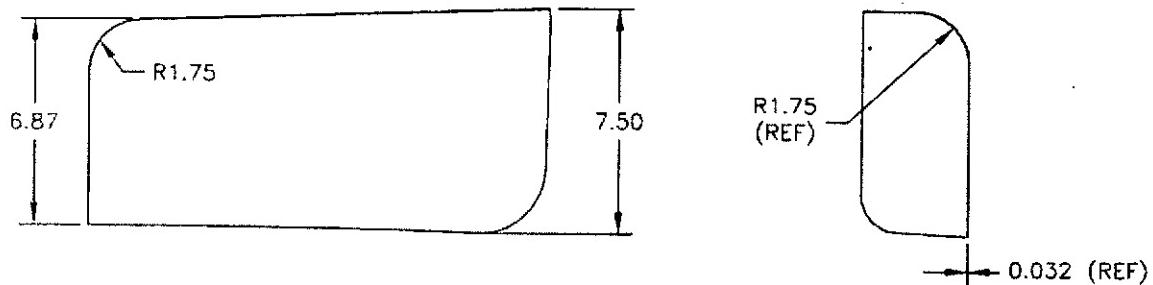


DESIGN 14	DRAWN BY 14	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED IP	APPROVED AH	DRAWING NO. D3255
		REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY
		SCALE 1:6
A	04.01.27	NEW ISSUE
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098

151 ED
05.01.08 ff



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)

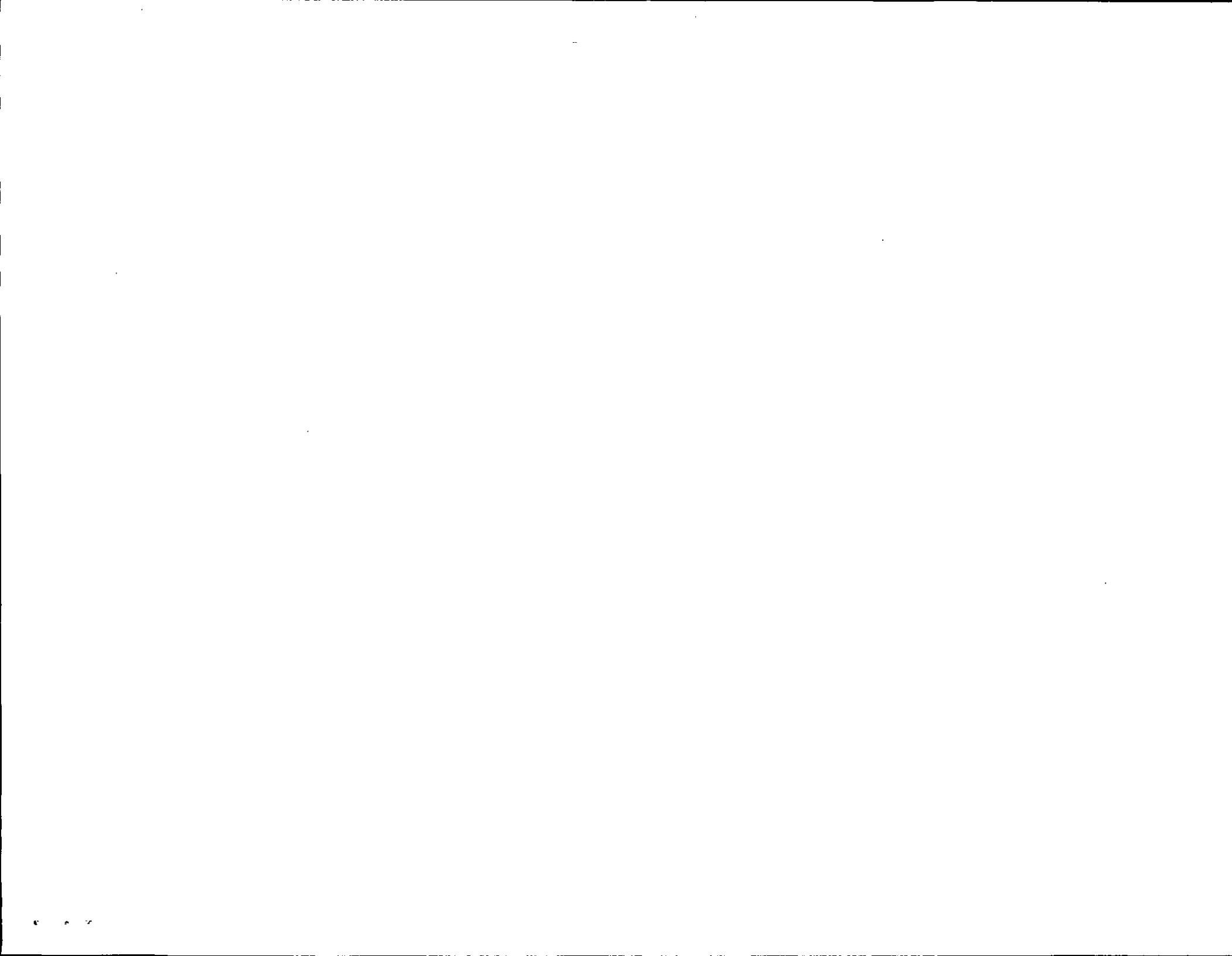


D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

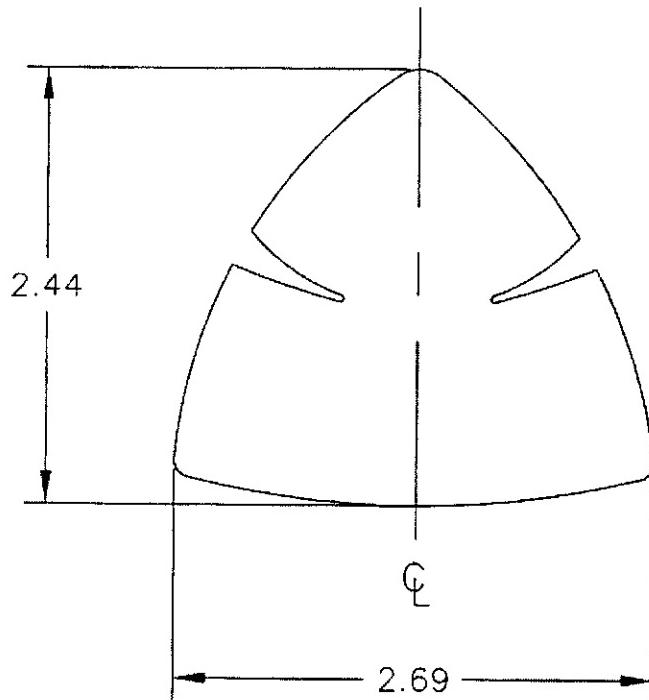
98951
13-04-10
MCU





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3255 REV. B SHEET 2 OF 4
DATE	TITLE	SCALE
04.12.06	TITLE	1:1

RELEASED
05/01/08



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

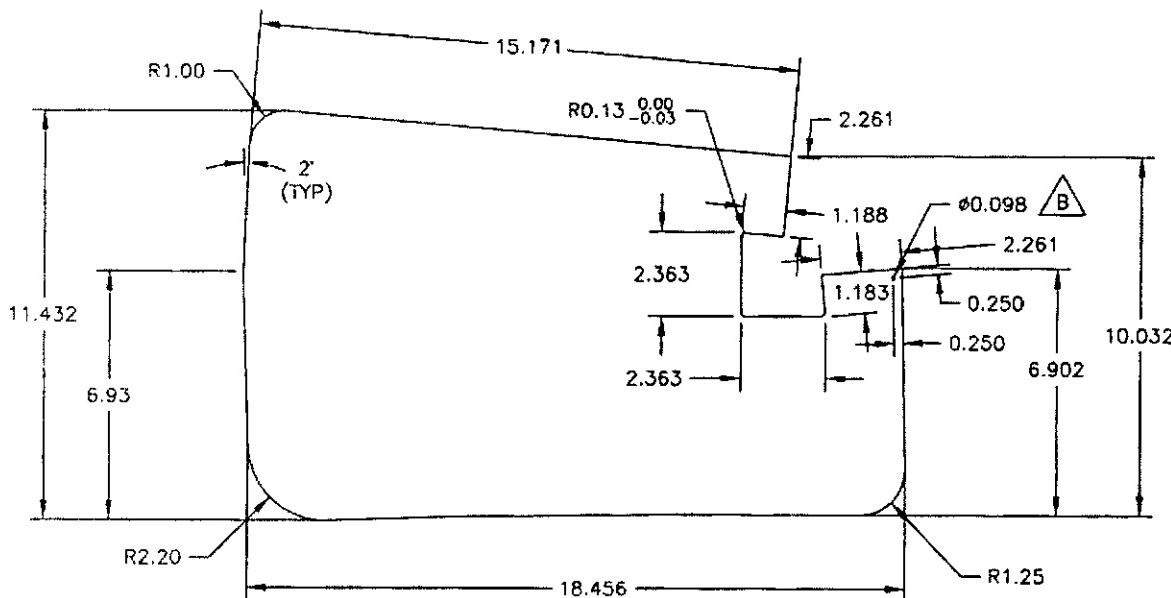
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

LS686



DART

DESIGN T.F	DRAWN BY T.F	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>ip</i>	APPROVED <i>ff</i>	DRAWING NO. D3255	REV. B	SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5	

*11.432 6.93 2' (TYP)
15.171 R1.00 R0.13 -0.03 2.261 1.188 Ø0.098 B
2.363 2.363 1.183 0.250 0.250 6.902 10.032
R2.20 18.456 R1.25***D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

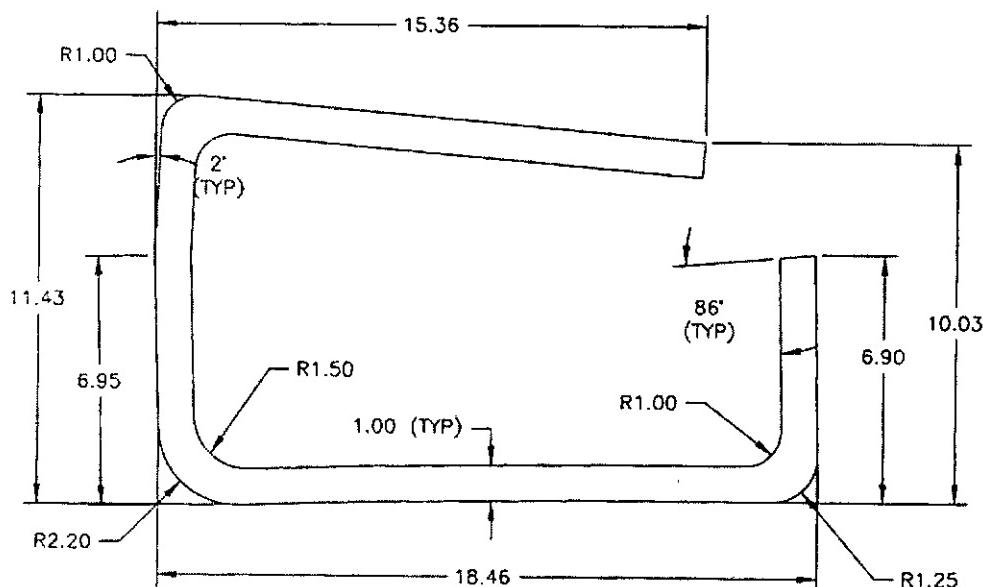
15696





DESIGN 17	DRAWN BY 17	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 16	APPROVED 17	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASER
DS 01/13 - HJD



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

94951

